

Work Order ID 55839

February 3, 2010 10:07:41 AM

Page 1

Item ID: D4005-5

Accept

Revision ID:

Item Name: Angle

Start Date: 2/03/10

Start Qty: 2.00

Required Date: 2/11/10

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: HDate: 10-2-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4005

~~A PRELIM~~ PAT now Rev. A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PLFProg Rev: LM

2-Deburr if necessary

RB 10-2-4

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 10-2-4**PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55839

February 3, 2010 10:07:41 AM



Page 2

Item ID: D4005-5

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/03/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 8/6/05

QC

Memo

0.00

Quality Control

(x4)

130

Deburr - SAs 10-02-05
Bend as per dwg

0.00

→ (5)

Brake NC

Memo

0.00

SP 10/02/09

(4)

Brake NC

8 → QCS inspect work → 8/6/09

(x4)

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

(4) bf 10-2-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55839

February 3, 2010 10:07:41 AM



Page 3

Item ID: D4005-5	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Angle					
Start Date: 2/03/10	Start Qty: 2.00		Cust Item ID:		
Required Date: 2/11/10	Req'd Qty: 2.00		Customer:		
Reference:					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run
	QC:	Date:	SPC (Y/N):	Date:	Start
					Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC Inspect part completeness to step on W/O <i>QC3</i> Memo	0.00 <i>10/06/10</i> 0.00				<i>(X4)</i>	<i>0</i>		
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>117</i> Memo	0.00 0.00				<i>10/06/28</i>	<i>(4)</i>		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>10/06/28</i>	<i>MF 10-2-19</i>

POSITIVE RECALL
EFFECTIVE *1002-03* AUTH *4*
RELEASED *4* DATE *1006-28*
at 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 10:07:44 AM

Page 1

Work Order ID: 55839



Parent Item: D4005-5



Parent Item Name: Angle

Start Date: 2/03/10

Required Date: 2/11/10

Comments: IPP rev A 10.02.01 new issue prelim EC verified by:JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	509.7133	3.7820			



2024-T3 .040 sheet



1810-2-4

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	509.7132789	
110305	184	
110337	6.4	
111786	32.0665789	
112291	49.4264	
112331	82.8641	
113162	154.9562	
113005		

(4)

113005

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

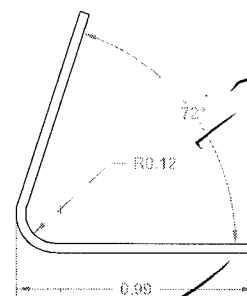
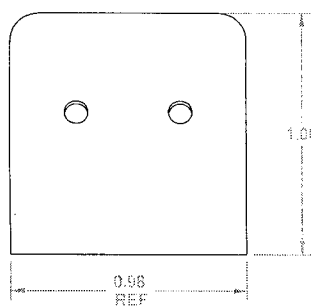
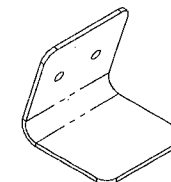
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-5	JCA-M47-2-06

x2



D4005-5 ANGLE

See RWA

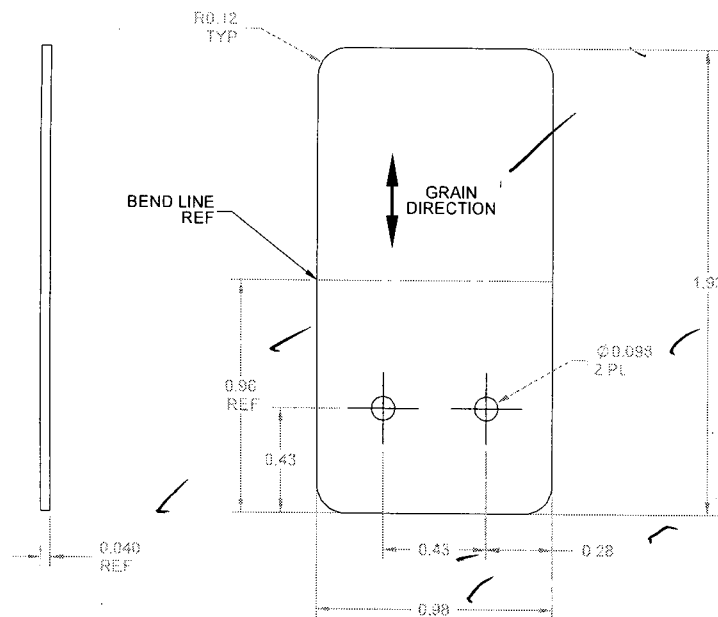
PRELIMINARY ISSUE

09.10.19

NOTES:

- 1) MATERIAL: MADE FROM D4005-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4005 TITLE FORWARD RESTRAINT SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		REV. PA1 SHEET 6 OF 15
DATE	09.10.19	



D4005-5F FLAT PATTERN

See Rev. A

NOTES:

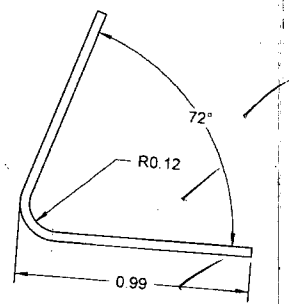
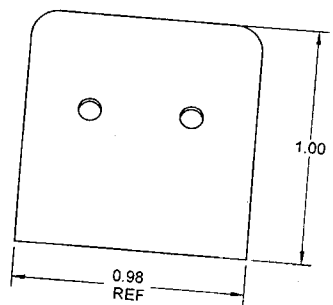
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

PRELIMINARY ISSUE

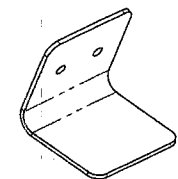
09.10.19

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MFG. APPR.		D4005	SHEET 7 OF 15
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DE APPR.		FORWARD RESTRAINT	NTS
DATE	09.10.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-5	JCA-M47-2-06



D4005-5 ANGLE



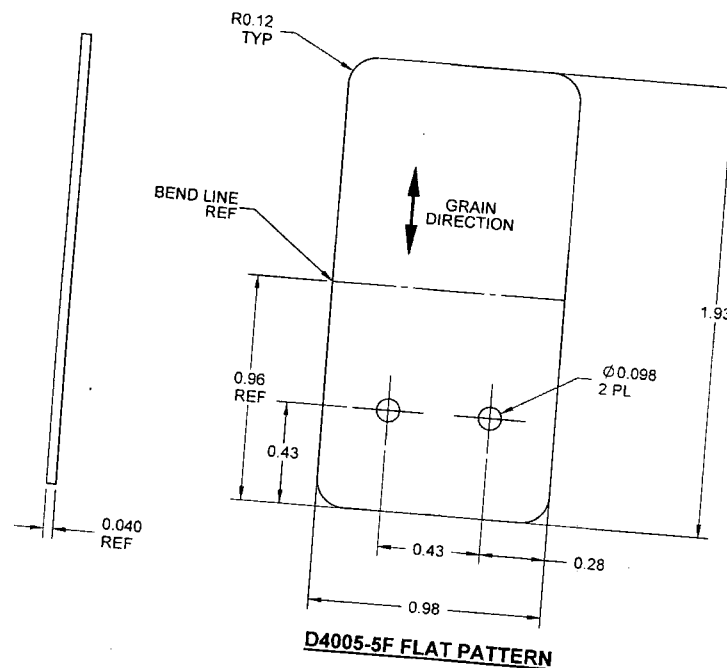
- NOTES:
- 1) MATERIAL: MADE FROM D4005-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-5" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.01 lbs

W/055839

RELEASED
R 2010-05-05
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	D4005
MFG. APPR.	13	TITLE	RESTRAINT
APPROVED	140	SCALE	NTS
DE APPR.	140	DATE 10.02.05	
DATE		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REV. A
SHEET 6 OF 15



NOTES:

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PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

W1055839

RELEASED
R 2010-05-05 D

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4005 TITLE RESTRAINT DATE 10.02.05	REV. A
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CHECKED			SCALE
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